



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

5095026

D3639-3

Job Sheet 180848



Part No: D3639-3

Job Qty: 12 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/17/18

Job Tracking No:

Due Date: 8/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		8/10/18	0.00	0.00	Start Up Waterjet		SC 8/6/18
100	Waterjet	12 pcs		8/10/18	0.00	1.57	Waterjet1		SC 8/10/18
110	QC	12 pcs		8/10/18	0.00	0.00	QC2 Waterjet-2		SC 8/10/18
120	QC	12 pcs		8/10/18	0.00	0.00	QC8-3		38
130	Brake NC	12 pcs		8/10/18	0.00	0.67	Brake NC 2		DAS-89 SB
140	QC	12 pcs		8/10/18	0.00	0.00	QC5		38
150	HandFinish	12 pcs		8/10/18	0.00	1.11	HandFinish1		SA 8-89 18-07-30
160	QC	12 pcs		8/10/18	0.00	0.00	QC7-2		DAS 18-08-02
170	Packaging	12 pcs		8/10/18	0.00	0.00	Packaging3-1	5/234	AUG 1 2018
180	QC21-SA	12 Ea		8/10/18	0.00	0.00	QC21	1-89 6	DAS 21 9-89 AUG 8 2018

Part Op 100 - 1-Cut as per Dwg D3639 Dwg Rev: A Prog Rev: A 2-Deburr if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Form as per Dwg D3639

140 - QC5- Inspect part completeness to step on W/O

150 - Chemical Conversion Coat per QSI005 4.1

160 - QC7-Inspect Chemical Conversion Coat

170 - Identify as per dwg & Stock Location:

180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.050	2024-T3 .050 Sheet	5.1325 sf (.42771 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.050	5	79	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____ Step #: _____

IOTV Effective : _____

MRB (QSI042) Approval _____

Description Work Order Deviation

Description Work Order Deviation

Container No: S095026
 Part: D3639-3
 Job No: 180848
 Serial No/Batch: S095026
 Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: _____
 Date: 07/23/18

By _____
 Supervisor
 rification
 Coordinator
 val
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 CANADA
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Root Cause					
Environment ☐	No Re-verification ☐	Pressure/Force ☐			
Design ☐	Operator ☐	Bending ☐			
Doc/Data ☐	Offset/Setup ☐	Centre Not Con ☐			
Equip/Tooling ☐	Supplier ☐	Cracks ☐			
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

DART AEROSPACE LTD		Work Order: 180848
Description: Doubler		Part Number: D3639-3
Inspection Dwg: D3639	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	Ø0.625	1		VSC-01	
Ø0.191	+0.005/-0.001	Ø0.192	1		Tg/R	
Ø0.098	+0.004/-0.001	Ø0.099	1			
0.45	+/-0.030	0.458	1			
1.350	+/-0.010	1.352	1			
2.25	+/-0.030	2.256	1			
3.15	+/-0.030	3.157	1			
4.05	+/-0.030	4.055	1			
4.95	+/-0.030	4.954	1			
5.85	+/-0.030	5.856	1			
6.75	+/-0.030	6.752	1			
7.65	+/-0.030	7.657	1			
8.55	+/-0.030	8.558	1			
9.350	+/-0.010	9.351	1			
9.45	+/-0.030	9.459	1			
10.350	+/-0.010	10.353	1			
11.25	+/-0.030	11.259	1			
12.15	+/-0.030	12.157	1			
12.85	+/-0.030	12.854	1			
13.86	+/-0.030	13.866	1			
13.96	+/-0.030	13.965	1			
0.805	+/-0.010	0.807	1			
1.00	+/-0.030	1.001	1			
2.100	+/-0.010	2.102	1			
3.30	+/-0.030	3.303	1			
2.000	+/-0.010	2.001	1			
2.590	+/-0.010	2.594	1			

Measured by: SC	Audited by: 38 9-89	Prototype Approval:	N/A
Date: 18/07/21	Date: JUL 24 2018	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.24	New Issue	KJ/EC/DD	